

Work Order ID 119212

May-13-14 10:42:47 AM

119212

Page 1

Item ID: D4978-5

Revision ID:

Item Name: Strut Thread

Start Date: 22/05/2014 Start Qty: 3.00

Required Date: 27/05/2014 Req'd Qty: 3.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4978

100

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Machine as per folio FB239

FOLIO REV: N/ADWG REV: B

Deburr

0.00

0.00

DAS

20

9-89 14-05-13

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS

20

9-89 14-05-13

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Item ID: D4978-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut Thread

Start Date: 22/05/2014 Start Qty: 3.00

3

Cust Item ID:

Required Date: 27/05/2014 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

30DAS
40

9-89

14/05/13

130

Identify as per dwg & Stock Location: W/A60

0.00

130

Packaging

Memo

0.00

Packaging

32 14-5-13

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ14-05-1314-5-13

Picklist Print

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Work Order ID: 119212

119212

Parent Item: D4978-5

D4978-5

Parent Item Name: Strut Thread

Start Date: 22/05/2014

Required Date: 27/05/2014

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 13.11.18 NEW ISSUE DD VERF:JLM IPP
REV:B 13.12.04 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R0.375

Purchased

No

f

6.5410

1

**

.850'

DAS
20
9-89

14-05-13

M304R0 375

304 ROUND BAR 0.375

Location

Loc Qty

Loc Code

MAT029

6.541

M127015

3.427

M127864

0.694

M128882

2.42

.850'

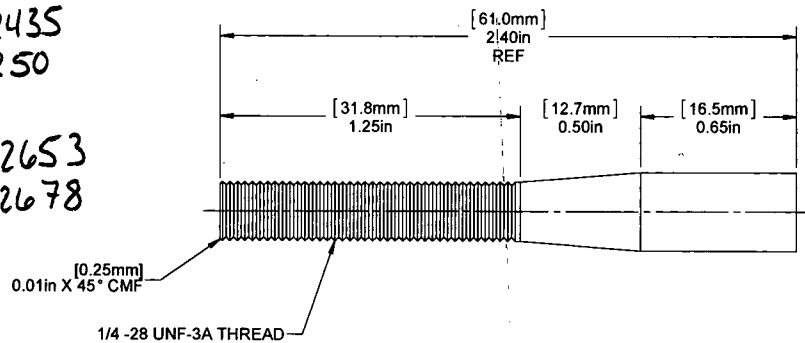
FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

Major ϕ .2435
.250

M.O.W. .2653
.2678



D4978-5 STRUT THREAD

NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR
PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs (0.02 kgs)

WORK IN PROGRESS

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4978	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.	DS	STRUT ASSY	NTS
DATE	14.05.07	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

[8.23mm]
0.324in
.365 +.005
-.000
J.M.
SEE ATTACHED
E-MAIL

12.1.12

Jean-Luc Menard

From: Harvey Siemens
Sent: May-13-14 10:41 AM
To: Jean-Luc Menard
Cc: Arkam Kindeel; David Shepherd; Mike Petsche
Subject: D4978-5 Strut Thread

JL

It is acceptable to make the larger diameter on this part to $0.365 +0.005/-0.000$ so that it fits the inside diameter of the tube.

Arkam

Please make this change to this part as part of your 189 CC project priorities.

Thanks

Regards,

Harvey